

ASAP

Date: Tuesday, 26/08/2008 7:28:44 AM  
User: Linda Lacelle

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 41619  
Estimate Number : 10437  
P.O. Number :  
This Issue : 26/08/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : SMALL / MED FAB  
Previous Run : 39564  
Written By :  
Checked & Approved By :  
Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC  
Est Rev:C Now on Waterjet 06-10-26 JLM

Drawing Name : WEARPLATE  
Part Number : D33191  
Drawing Number : D3319 REV. B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 02/09/2008 Qty: 9 Um: 42 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s)

1010/1025/A21/6aA SHEET .048

Batch: ~~10571~~

IB 8-8-26

9.  
 $104921 \times 6 = 4$   
 $165084 \times 7 = 5$

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: ~~B~~

Prog Rev: ~~B~~

IB 8-8-26

(B)

2-Deburr if necessary

IB 8-8-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-8-26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/08/26 (x13)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

n/a

5  
Dre at 0.00 #2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Part Number: D33191

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B  
2- Form flat on press using DT8776 block

08/08/29 (9)  
SR 08/09/08

(9)

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/09/08 (9)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3  
2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

(X9)

Qty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod M106762

EL 8-9-10

9.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/09/10 (X9)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/10 (X9)

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:20am  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 11:50am

08-09-10

(X9)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/09/10 (X9)

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Drawing Name: WEARPLATE

Job Number: 41619

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



9x

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 496

8/9/10

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





h 08/09/11



**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA



- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN		DRAWN BY		REV. B	
P41		P44			
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 5	
		D3319			
DATE	TITLE		SCALE		
05.06.06	WEARPLATE		1:8		
A	04.09.24		NEW ISSUE		
B	05.06.06		WIDEN HOLES, REDUCE WIDTH -3/-5/-7		

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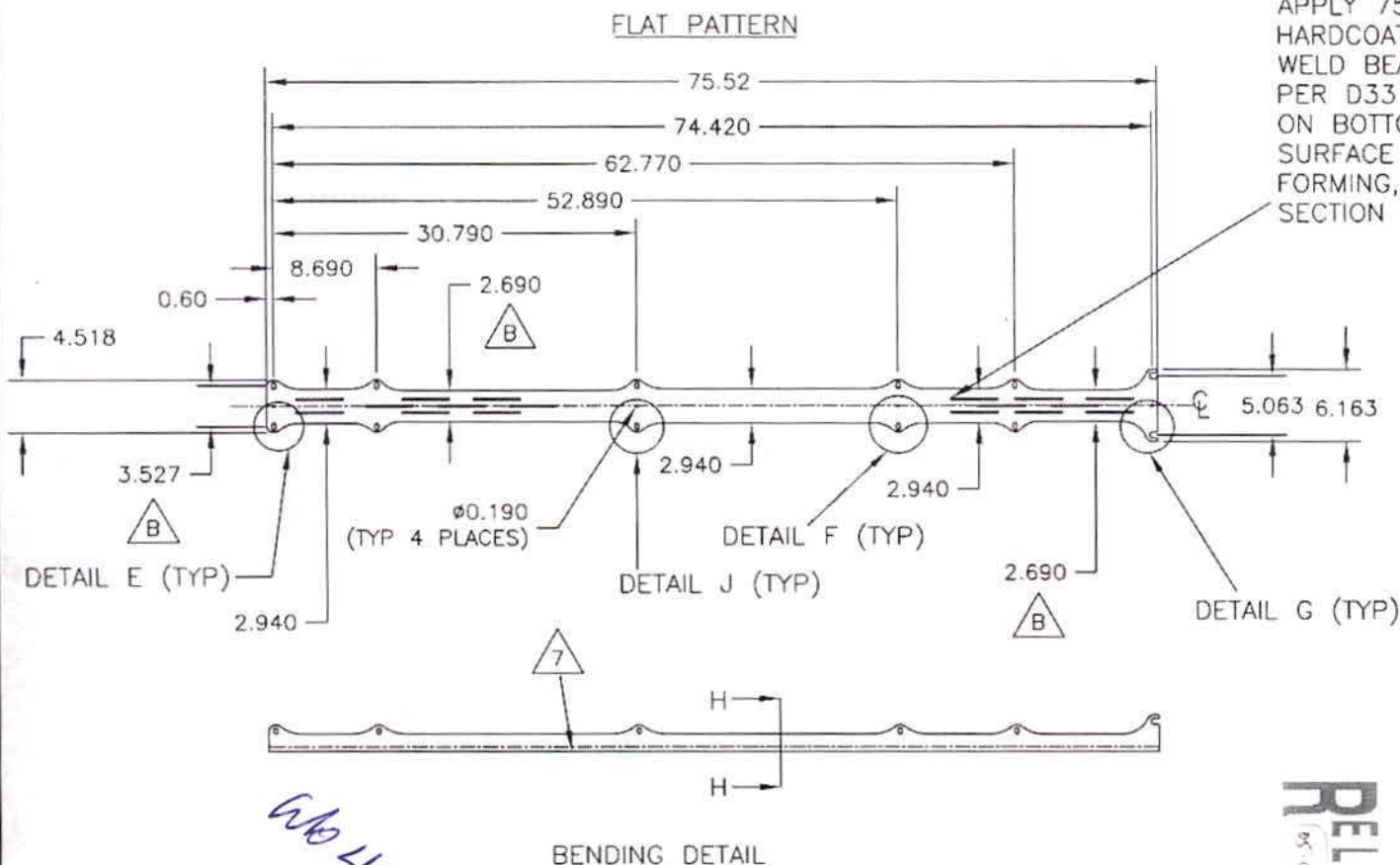
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CHECKED	APPROVED	DRAWING NO.
67	67	D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 2 OF 5
		SCALE
		1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



#### D3319-3 WEARPLATE

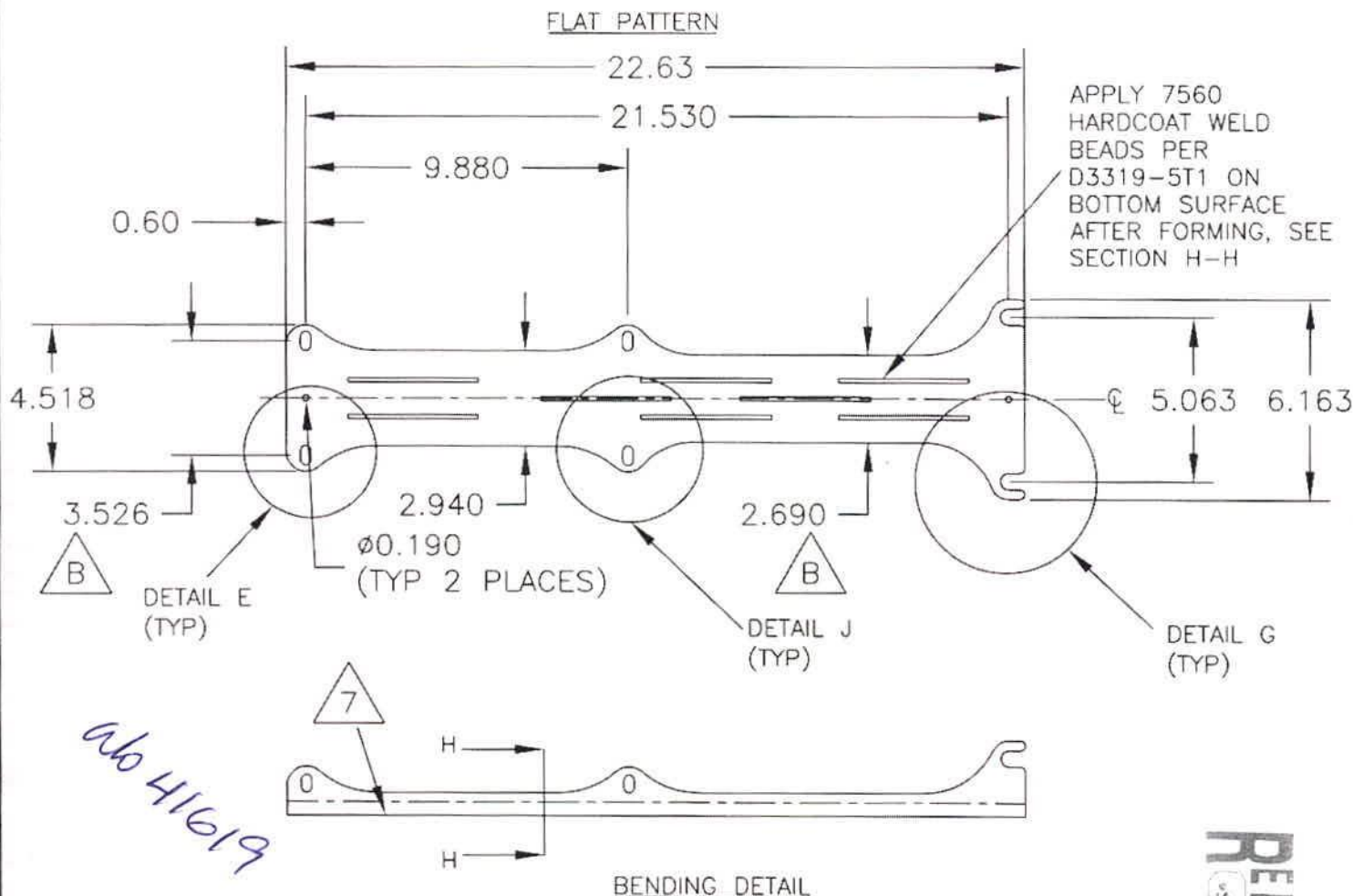
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- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 5
				SCALE 1:5



#### D3319-5 WEARPLATE

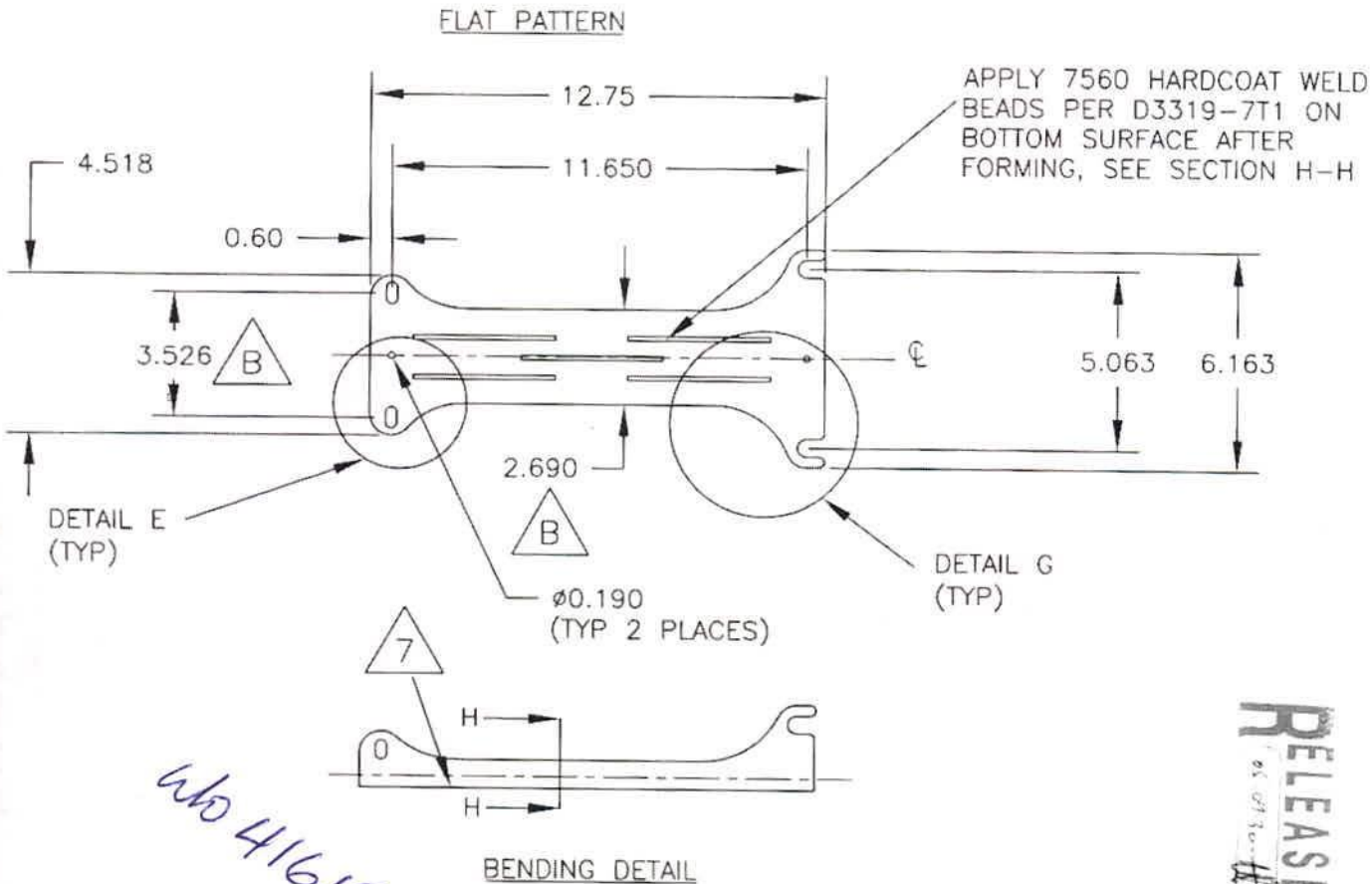
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
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- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
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FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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PH	PH	TITLE	SCALE
05.06.06		WEARPLATE	1:5

RELEASED  
05 07 30-11



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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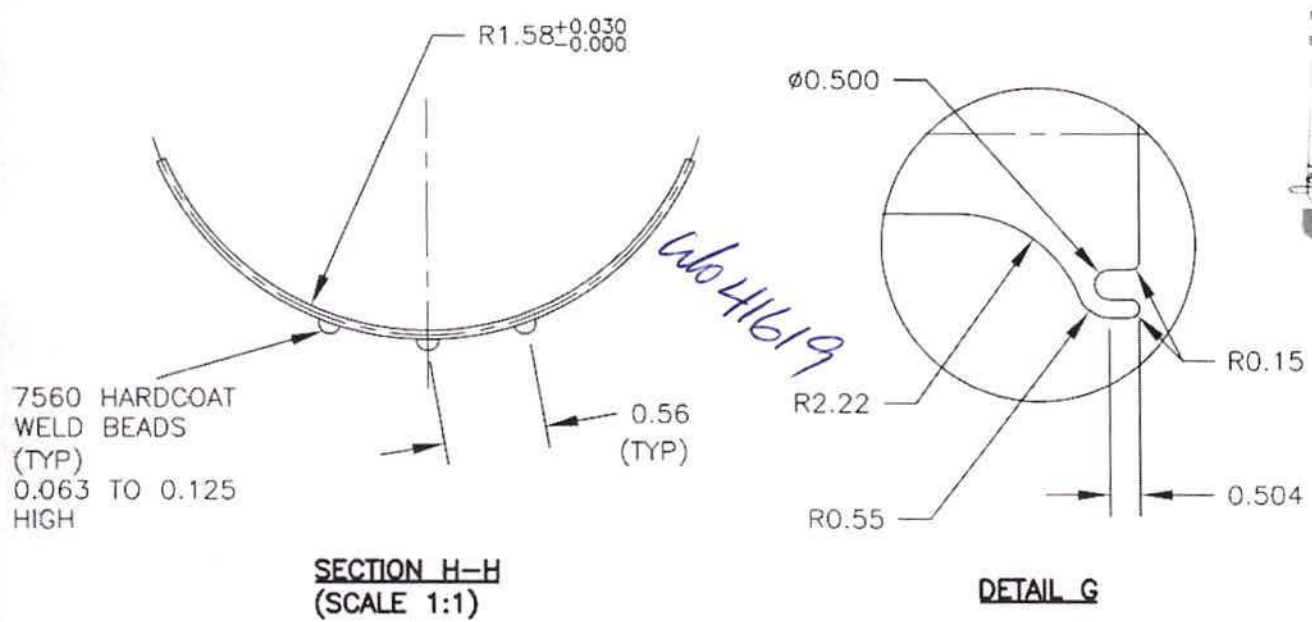
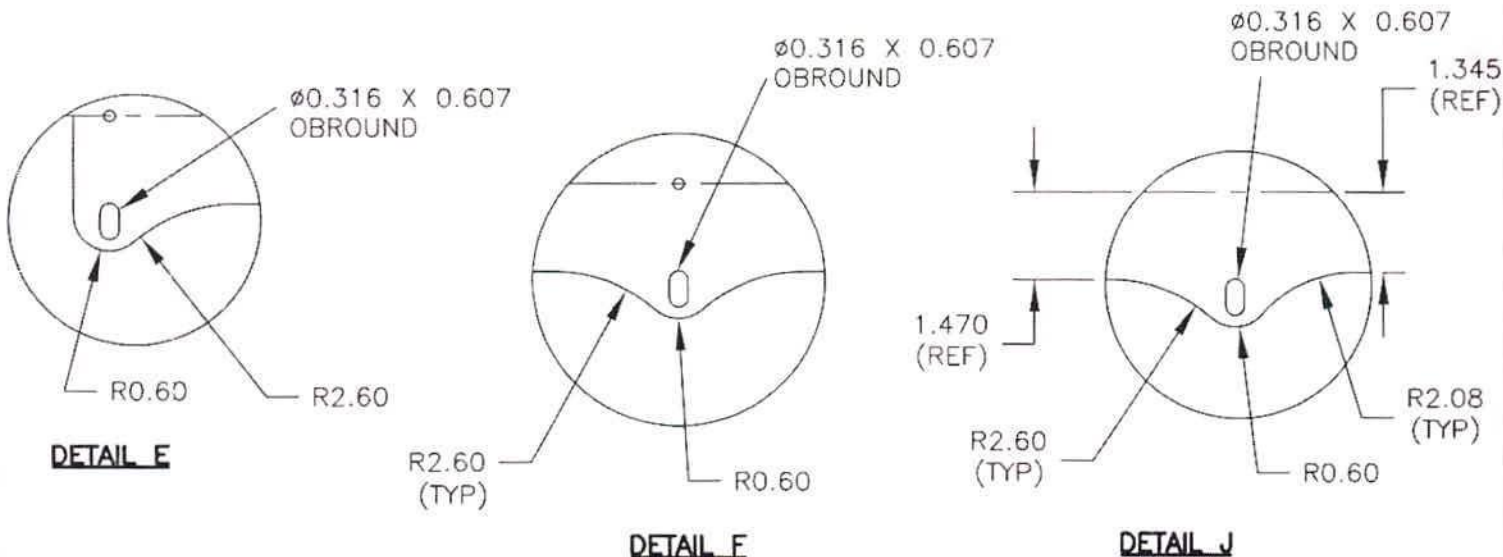
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DATE	05.06.06	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3319	SHEET 5 OF 5
		SCALE	1:3	

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